Work Order	r ID 600	)23				:					
Tuesday, June 22,		59 PM		1 ( <b>88</b> 4) <b>8</b> (14) <b>8</b>	9111 <b>88</b> 11 <b>8</b> 11 <b>888</b> 1111 1 <b>08</b> 1	# · · · · · · · · · · · · · · · · · · ·					Page
Revision ID:	04045-1 ug			Accept				Setup	Start		
Start Date: 6/2 Required Date: 7/2 Reference:		Start Qty: 6.00 Req'd Qty: 6.00			Cust Item Customer:				Stop		<b>i i i i i i i i i i i i i i i i</b> i
. Q	Process Plan: QC:	:	Date: 10-6-2	2-Tooling: SPC (Y/N):		ate:	-	Run	Start Stop		
equence ID/ Vork Center ID		Operation		Set Up/	Tool ID						
Draw Nbr		Description on Nbr		Run Hours	10011D	Tool # Plan Code	Accept Qty	Rej Qty		Reject Iumber	Insp.
D4045	A	7.101						213		umper-	Stamp
00 IIII IIII IIIIIIIIIIIIIIIIIIIIIIIIII		Memo cut blank	□1.150" long	0.00 0.00 Anf	10/06/24	- 1	· 6		B _		
0 AAS I AAS CNC vertical mach	hine#1	<b>Memo</b> mill as per DWG REV	dwg and folio fa887	0.00	106/24				<i>&amp;</i>		

W/O:			V	/ORK ORDER CHA	NGES			1		•
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	City	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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								1		
Part No		PAR #:							Date:	<del></del>
	Resolution:								Date: _	
NCR:		V	VORK OR	DER NON-CONFOR	RMANCE	E (NCR	)			
DATE	STEP Description of NC				Section B	———— verifica			Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Descripti Chief Eng	on ·	Date	Section	C	Chief Eng	QC Inspector
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# Work Order ID 60023

Tuesday, June 22, 2010 3:24:59 PM



Page 2

Item ID: **Revision ID:** 

D4045-1

Accept

Setup Start

Stop



Item Name: **Start Date:** 

Lug

6/22/2010 Required Date: 7/30/2010 Start Qty: 6.00 Req'd Qty: 6.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Tooling:

Date:

Run

Reject

Start

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Sequence ID/ **Work Center ID** 

120

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours** 

0.00

Tool ID

Qty Qty

Accept

Reject Number

Insp. Stamp

Memo

QC8- Inspect parts - second check

0.00 Into/06/24

130



0.00

0.00

Quality Control

Memo

140

Packaging

Packaging

Identify as per dwg & Stock Location;

Memo

0.00

N 10.06.24

W/O:			W	ORK ORDER CHANG	GES					۶ ,
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	City	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
	Re	esolution:						1	Date: _	
NCR:	i		WORK ORI	DER NON-CONFORM	ANCE	(NCR	3)			
DATE	STEP	Description of NC				ection B  Sign & Section			Approval	Approval
	<b>0.2.</b>	Section A	Initial Chief Eng	Action Description Chief Eng		Date	Section	n C	Chief Eng	QC Inspector
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-17 - 173 										
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# Work Order ID 60023

Tuesday, June 22, 2010 3:24:59 PM

Lug



Page 3

Item ID: Revision ID:

Item Name:

**Start Date:** 

D4045-1

6/22/2010

Accept

Setup Start

Required Date: 7/30/2010

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

**Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Date:\_\_\_\_

Date:

Tooling:

Date:

Date:

Run

Start

Stop

Stop

Sequence ID/ Work Center ID

Operation Description

Set Up/ Run Hours

SPC (Y/N):

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

150

QC21- Final Inspection - Work Order Release

0.00

10/06/2 CX10/6/25

Quality Control

Memo

0.00

V/O:		· · ·	WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Q	у	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQA	:		_ Date: _	
	R	esolution:	Disposit	ion:	QA	: N/C CI	osed:	+		Date:	
NCR:			WORK OR	DER NON-CONFORM	ANCI	E (NCF	R)				
DATE	STEP	Description of NC	cription of NC Corrective Action Se			0:	Verifica	atio	n	Approval	Approval
	3127	Section A	Initial Chief Eng	Action Description Chief Eng		Sign 8 Date	Sectio	nÞ		Chief Eng	QC Inspector
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	<u>L</u>						<u> </u>		1		

# **Picklist Print**

Tuesday, June 22, 2010 3:25:04 PM

Work Order ID: 60023

Parent Item: D4045-1

Parent Item Name: Lug



Start Date: 6/22/2010

Start Qty: 6.00

Loc Code

Required Date: 7/30/2010

Page 1

Required Qty: 6.00

Comments:

IPP Rev:A as per dwg revA DD 10.02.18 verified byEC

Component Item ID/	Replacement		Bin Primary Lost D										
M304B1.000X1.000	Item ID	Purch	Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
304 bar 1.00 x 1.00	)	Purchased	No			100	f	16.2184	0.0951	0.600632	)		

Location MAT54

113290

<u>Loc Oty</u> 16.21837368

16.2183737

:600632 onl 10/06/24

W/O:	Ì		VVC	ORK ORDER CHANG	3E3			f		•
DATE	STEP	PRO	CEDURE CHA	NGE	I	Зу	Date	City	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	ļ									,
		PAR #:	Fault Cate	gory:	NCR:	Yes N	o DQA:		Date:	
	R	esolution:	Disposition	1:	QA: N	/C Clo	sed:		Date:	·
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (	NCR)				
DATE	STEP	Description of NC			tion B	<u> </u>	Verifica	on	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	,	Sign & Section			Chief Eng	QC Inspector
	-									
								,		
					)   					

DART AEROSPACE LTD	Work Order:	60023
Description: (116		134045-1
Inspection Dwg: 194045 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype											
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments					
.75	I,036	749									
.13	±.030	.128		6							
R.03	±-030	R.030									
-25	=,036	.248									
.25	±.036	.249									
1.03	±.030	1.027									
.63	±.030	.627									
.713	±.01D	.7/3									
8.257	+ .006	B. 258									
R.31	=.030	R.310									
						/					
						·					
	<u> </u>										
•		*									

 Measured by:	and	Audited by:	μа		Prototype Approval:	N/A
Date:	10/01/24	Date:	10/06	124	Date:	N/A
			J J U			

Rev	Date	Change	Revised by	A
A		New Issue		Approved
<del></del>	· · · · · · · · · · · · · · · · · · ·	TOW TOOLS	KJ/JLM	1

8 D 0.13 0.63 -Ç 0.25 0.713 R0.03 SHOP COPY 1.03 RETURN TO ENGINEERING **UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE Ę Ø0.257 R0.31 WORK ORDER D4045-1 LUG NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC. M304B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.05 lbs NEW ISSUE REV. 10.01.29 DESCRIPTION BY DESIGN DATE RF DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. MFG. APPR. D4045 REV. A APPROVED SHEET 1 OF 1 TITLE DE APPR. SCALE LUG NTS 8 DATE COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS COCLUENT IS PRIVATE AND CONTRICTION AND SUPPLIED OF THE COPERS CONCERN
HIGH TO BE LIBED FOR ANY PROPOSE OR COMBANICATED TO MY OTHER PRISO
WHITTIN PROMISSION FROM DATA REPOSPACE IT. 7 10.01.29 5 4 3 2

W/O:			WC	RK ORDER CHANGE	ES			*		
DATE	STEP	PRO	CEDURE CHAI	NGE	В	У	Date	Qy	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		PAR #:	Fault Category: NCR: Yes No DQA:				A: Date:			
÷	Resolution:			1:	QA: N	C Clo	sed:	_	Date: _	
NCR:		WORK ORD	R NON-CONFORMA	NCE (I	VCR)					
		Description of NC	Corrective Action		Section B Verific			ton Approva	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng				C Chief Eng		
										8
	7									

NOTE: Date & initial all entries

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